

Work Order ID 131502

Monday, April 13, 2015 10:03:51 AM

131502

Page 1

D205-341-044

Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid
Start Date: 4/13/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/1/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: mf. Date: 15-4-13 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	G								

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00
Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436

INSTALL D2012-117 CLEVIS ONLY ON D130-701-XXX

2- WELD MESH AND REMOVE SECTIONS OF MESH WHERE
INDICATED AS PER DWG

1x CC 15-5-4

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 13-05-07 DAS
9
9-89

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Item ID: D2512

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid

Start Date: 4/13/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/1/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 9 9-89
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

① 15-05-07

1 φ 15-5-7

233

Work Order ID 131502

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
130	<i>M131545.</i>	0.00				<i>1</i>	<i>0</i>	<i>15-5-7.</i>	<i>DAS 34 9:59</i>
Powdercoat	Memo								
Powder Coating	1- Plug all holes prior to Powdercoat								
	1ST COAT:								
	START TIME: <i>10:20.</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>10:50.</i>								
	2ND COAT:								
	START TIME: <i>11:15.</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>11:45.</i>								
140		0.00							
140	HandFinishing	0.00				<i>1</i>	<i>0</i>	<i>15-5-7.</i>	<i>DAS 34 9:59</i>
HandFinish	Memo								
Hand Finishing	Wing Wash and Spray Paint black as per Dwg D2512 and QSI 005 4.4								
	Batch: <i>132039</i>								

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Required Date: 5/1/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>D-205-541-044 B. B1513</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

1 0 15-5-7 234 988
1 all 15/5/11 61
15/5/11 988
mf
15-5-11

Picklist Print

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Work Order ID: 131502

131502

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R
 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS
 PER DWG REV:F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG
 REV.G DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117

N/A

Manufactured No

100

Each

28.0000

2

2

D2012-117

Clevis

DL 15/4/22

Location

Loc Qty

Loc Code

WA004

28

124563

11

125440

7

127735

10

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

D2232-1

Manufactured No

100

Each

29.0000

2

2

D2232-1

Basket Hinge

DL 15/4/22

Location

Loc Qty

Loc Code

WA004

29

105333

15

105885

14

D2236

Manufactured No

100

Each

0.0000

4

4

D2236

Lid Rib

DL 15/4/22

131509

4

Picklist Print

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Page 2

Work Order ID: 131502

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

18.0000

1

1

D2506

Label Plate

Dh 15/4/22

Location

Loc Qty

Loc Code

WA004

18

102257

11

103156

2

99826

5

D2512-3

Manufactured No

100

Each

4.0000

2

D2512-3

Rib

2

Dh 15/4/22

Location

Loc Qty

Loc Code

WA004

4

127398

4

D2512-5

Manufactured No

100

Each

0.0000

6

6

D2512-5

Rib

6

Dh 15/4/22

D2512-7

Manufactured No

100

Each

4.0000

3

3

D2512-7

Rib

Dh 15/4/22

Location

Loc Qty

Loc Code

WA004

3

125423

3

WA006

1

125424

1

B131508 → *(2x)*

(1x)

Picklist Print

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Work Order ID: 131502

131502

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 91.0000 2 2

D2581

Mounting Bracket

Dh 15/4/22

Location

Loc Qty

Loc Code

WA004

91

102265

36

127716

39

131144

16

D3825-043 Manufactured No 100 Each 0.0000 2 2

D3825-043

Rib Assembly (Basket End, Lid)

D3832-13

Manufactured No

131512

100

Each

0.0000

2

2

2

Dh 15/4/22

D3832-13

Mesh (Lid)

D3833-7

Manufactured No

100

Each

13.0000

2

2

CC 15-4-30

D3833-7

Mesh (Lid End)

Location

Loc Qty

Loc Code

WA004

4

127675

2

127676

2

WA006

9

105442

1

114377

8

(2)

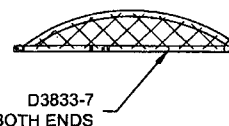
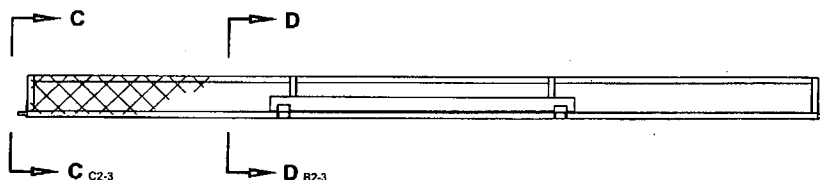
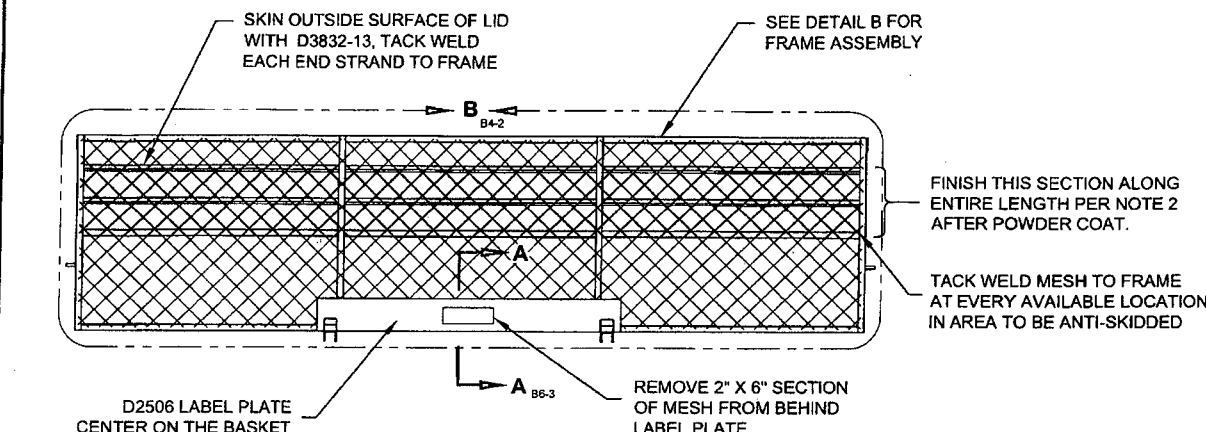
QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

G

RELEASED
2012-09-03

G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION: REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 85.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	DE	DRAWING NO. D2512
MFG. APPR.	DE	REV. G SHEET 1 OF 4
APPROVED	DE	TITLE BASKET LID ASSEMBLY (350/212)
DE APPR.	DE	SCALE NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND APPLY BLACK ANTI-SKID TO OUTSIDE SURFACES PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
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OTHER :																									

8 7 6 5 4 3 2 1

D

D

C

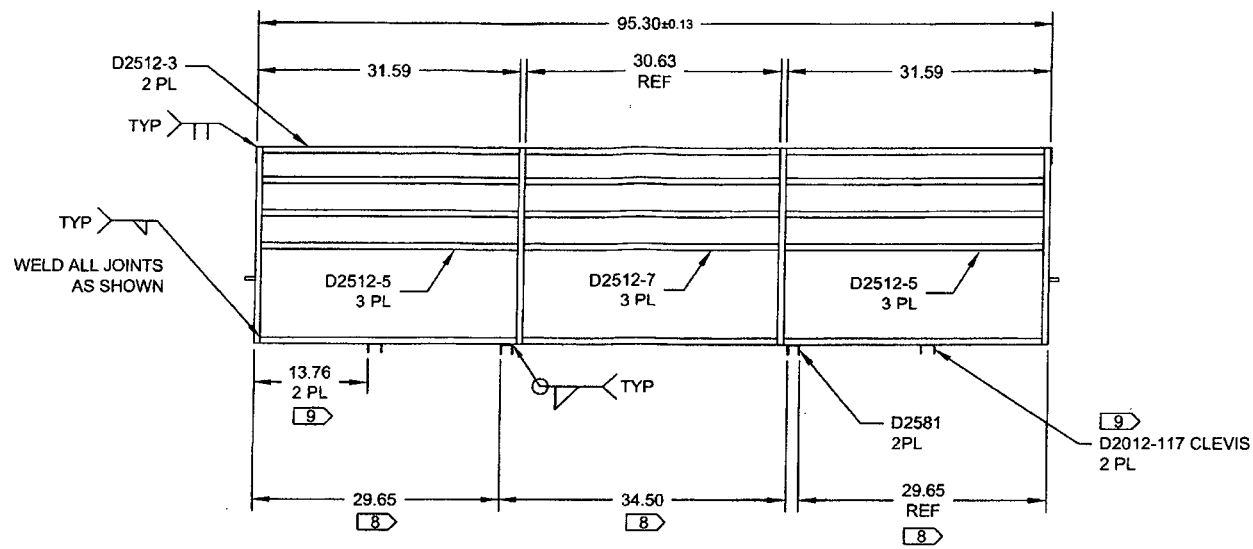
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B

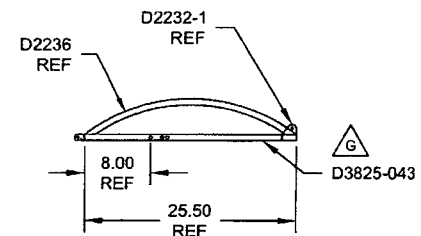
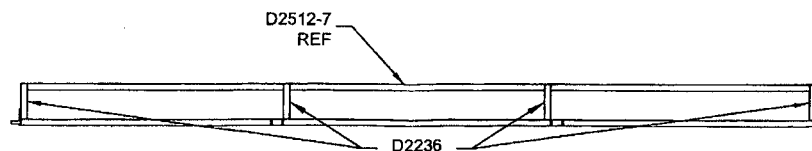
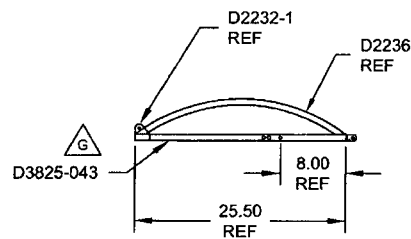
B

A

A



DETAIL B D6-1
FRAMEWORK ONLY SHOWN FOR CLARITY



RELEASED
R 2012-00-03
JMP

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

DQA: _____ Date: _____

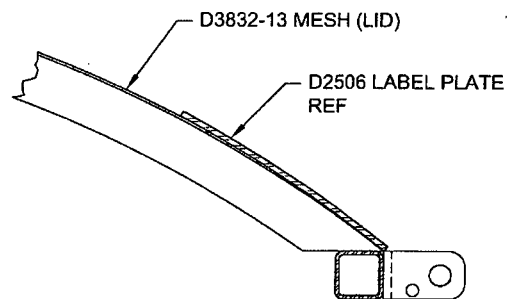


WORK ORDER NON-CONFORMANCE / UPDATE

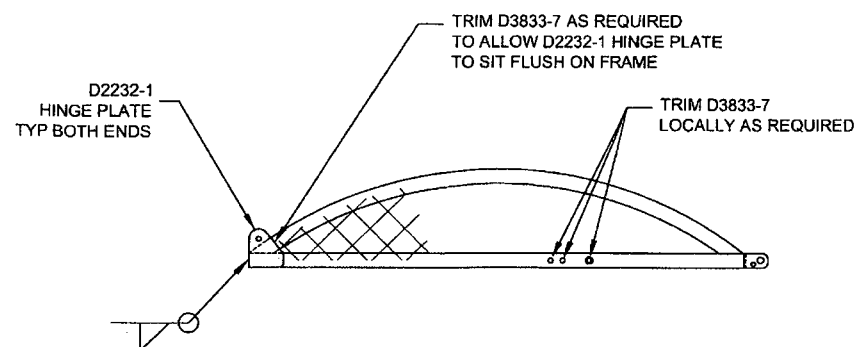
QA Closed: _____ Date: _____

Work Order update only ☐

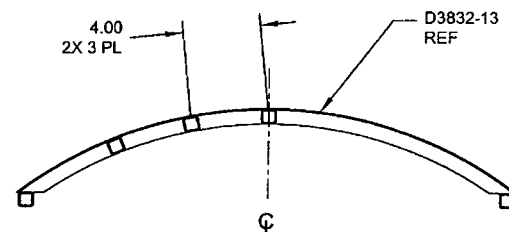
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SECTION A-A
(ROTATED 90° CCW) C6-1



VIEW C-C SIMILAR BOTH END RIBS B6-1



SECTION D-D SAME BOTH CENTER RIBS B7-1

RELEASED
2012-08-03
MP

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____

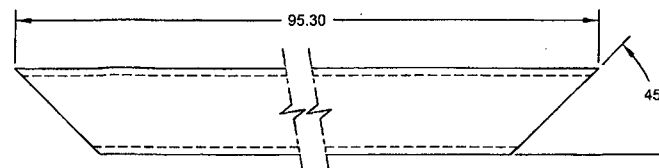
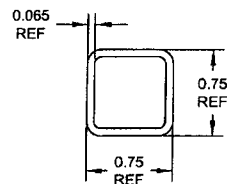


WORK ORDER NON-CONFORMANCE / UPDATE

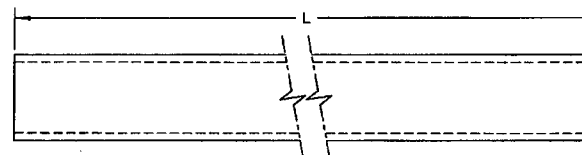
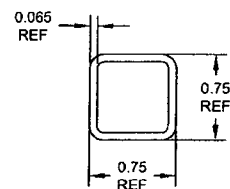
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



D2512-3 RIB



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

RELEASED
2012-08-03

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	BW	DART AEROSPACE LTD
DRAWN	B	HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. G
MFG. APPR.	[Signature]	D2512 SHEET 4 OF 4
APPROVED	[Signature]	TITLE SCALE
DE APPR.	[Signature]	BASKET LID ASSEMBLY (350/212) NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
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					Lead hand / Supervisor Approval Verification	
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OTHER : ☐						